Memo

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Work	()rder	11)	63354

QC

Quality Control



Page 1

Wednesday, October 27, 2010 4:04:13 PM Item ID: D3255-041 Accept Setup Start **Revision ID:** Stop Access Panel Assembly Item Name: 10/27/2010 Start Qty: 2.00 **Start Date: Cust Item ID: Required Date: 11/11/2010** Rea'd Otv: 2.00 **Customer:** Reference: Run Start Date:/0/10 Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: Tool ID Sequence ID/ Set Up/ Tool # Plan Reject Reject Accept Insp. Operation Description Oty Otv Number Stamp Code Work Center ID **Run Hours Draw Nbr Revision Nbr** Rev B D3255 0.00 100 Large Fab Large Fab 0.00 Memo Large Fab 1-Weld as per Dwg D3255 ***purge weld***□A/R SS ROD □2-Grind Welds Flush 110 QC10- Inspect visual per QSI004- ground welds 0.00 Memo Quality Control 120 OC5- Inspect part completeness to step on W/O 0.00 0.00

Dail Ac	ospace	Liu							
W/O:			WO	RK ORDER CHANG	ES				٠ .
DATE	STEP	PRO	OCEDURE CHAN	OCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition	_ QA: N/C C	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	3)			
		Description of NC		on B	Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	🗴 Sect	tion C	Chief Eng	QC Inspector
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Work Order ID 63354

Wednesday, October 27, 2010 4:04:13 PM



Page 2

Item ID:

D3255-041

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Access Panel Assembly

Start Date:

Required Date: 11/11/2010

10/27/2010

Start Oty: 2.00 Req'd Oty: 2.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date: Date: Run Start

Reject

Qty

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Number Stamp

2 BP 11-01-19

Insp.

Sequence ID/ Work Center ID

Powdercoat

Powder Coating

Operation Description

Grev Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

8:15 DOVEN TEMPERATURE:

140

Quality Control

QC3- Inspect Part Finish

=1 M 11/01/14

Memo

Memo

150

Small Fab

Small Fab

Small Fab

0.00

0.00

0.00

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg

D3255□A/R , 736 DOW CORNING ADHESIVE

Batch: M 1/66 4

Sp 11/02/01 (2)

Dart Aei	Jart Aerospace Ltd								
W/O:			WO	RK ORDER CHANGE	S				t ,
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Resolution:		Disposition	QA: N/C CI	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section	Section B		oation	Approval	Ammercal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Verification Section C		Approval Chief Eng	Approval QC Inspector

Work Order ID 63354

Wednesday, October 27, 2010 4:04:13 PM



Page 3

Item ID:

D3255-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Access Panel Assembly

Start Date:

10/27/2010

Start Otv: 2.00

Required Date: 11/11/2010

Req'd Oty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Date: Date: Run

Start Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

OC: Date:

Memo

Memo

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Mozlo2 H MF -01.

	WORK ORDER CHANGES							
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
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Picklist Print

Wednesday, October 27, 2010 4:04:19 PM

Work Order ID: 63354

Parent Item:

D3255-041

Parent Item Name: Access Panel Assembly



Start Date: 10/27/2010

Required Date: 11/11/2010

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	, Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1	 	Manufactured	No			100	Each	5.0000) ² P(11:01	17		
				Location	1	Loc	<u>Oty</u>	Loc Code		•			
	•			ST176	61246		4 4		_		-		
				WA	46857		1 1				<u>.</u>		
D3255-5		Manufactured	No			100	Each	5.0000		2			
Gasket				Location ST047	863588	Loc (<u>Oty</u> 5	Loc Code	ع.	3638	1/28	<u> </u>	<u>ව</u> ම
D3255-3		Manufactured	No		60207 X C	move e nore	5 Each	6.0000	1	² 9(11	01.17		
Сир				<u>Location</u> WA	<u>1</u> 48315	Loc	Oty 6 . 6	Loc Code		36	3857	⁷ >	- (=

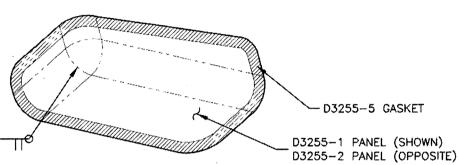
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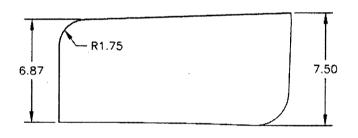
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В		04.12.06	D3255-3 REDESIGN: ADDED Ø0.098

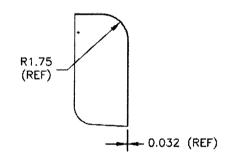


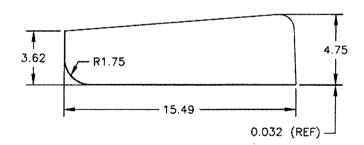
WELD D3255-3 ·



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)







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D3255-1 BEND DETAIL D3255-2 OPPOSITE

NO. DP10-10-21

<u>D3255-041/-042 NOTES:</u>
1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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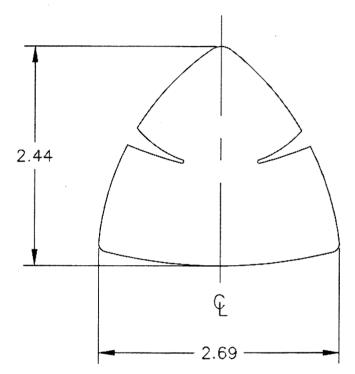
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	R	esolution:	Disposition:			I/C Clos	sed:	<u> </u>	Date: _		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)					
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D3255-3 CAP FORM TO FIT D3155-1/-2

Who 63354

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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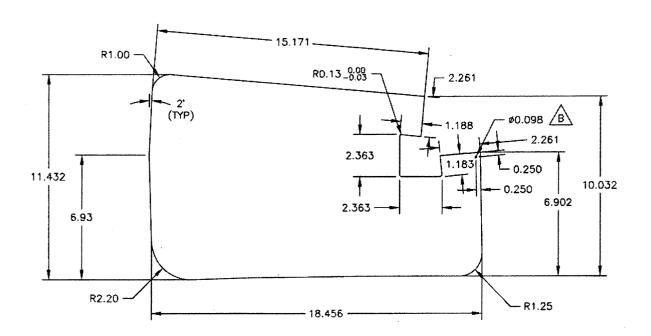
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04.12.06		ACCESS PANEL ASSEMBLY	1:5





ule 43359

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

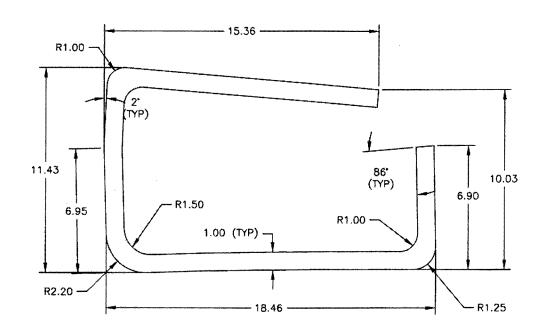
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04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

W/0 43359

D3255-5 NOTES:

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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